

# Work Order ID 59693

Wednesday, June 09, 2010 2:30:14 PM



Page 1

Item ID: D3202-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Cover				
Start Date: 6/9/2010	Start Qty: 10.00		Cust Item ID:	
Required Date: 7/2/2010	Req'd Qty: 10.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>M</u>	Date: <u>10-6-09</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3202	Rev D								

100



Waterjet  
FLOW CNC Waterjet

5052 .032

## Memo

1-Cut as per Dwg D3202  
Dwg Rev: D  
Prog Rev: D

2-Deburr if necessary

0.00

9.00

B 10-9-15

10

110



QC  
Quality Control

QC2- Inspect parts off machine FAI/FAIB

## Memo

0.00

0.00

B 10-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3202-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 6/9/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.10/0.17

7.10

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 10/09/24

210

0

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M 112588

BR 10-9-21

10

10

START TIME: 10:30  
OVEN TEMPERATURE: 320°  
FINISH TIME: 11:00

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Wednesday, June 09, 2010 2:30:14 PM

**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Stop**

**Insp.  
Stamp**

0.00

0.00

## Memo

## Quality Control

0.00

0.00

### Packaging

## Packaging

0.00

0.00

QC

## Quality Control

MF

10-9-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, June 09, 2010 2:30:17 PM

Page 1

Work Order ID: 59693

Parent Item: D3202-1

Parent Item Name: Cover

Comments: IPP Rev:B No Longuer Made In House 05-11-06 JLM  
IPP Rev:C Now on Waterjet 07-04-18 JLM  
IPP Rev:D chg to revC as per dwg 08-04-21 DD verified by:JLM

Start Date: 6/9/2010

Required Date: 7/2/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M5052H32S.032		Purchased	No			100	sf	60.6000	1.551	16.32632			



5052-H32 .032 Sheet



B10-9-15

Location

Loc Qty

Loc Code

MAT23

60.6

100470

3

103321

3

105998

7

108462

6.3

109478

9

111448

3

112664

26.3

15031

3

115 638

115 638

10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



D3065-5DART AEROSPACE LTD		Work Order:	59493
Description: Cover		Part Number:	D3202-1
Inspection Dwg: D3202	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.38	+0.006/-0.001	.380	<del>X</del>		✓ BO2	
0.63	+/-0.030	.628	<del>X</del>		✓	
3.38	+/-0.030	3.385	<del>X</del>		✓	
2.40	+/-0.030	2.403	<del>X</del>		✓	
0.82	+/-0.030	.816	<del>X</del>		✓	
73.84	+/-0.030	73.84	<del>X</del>		T HB01	
74.50	+/-0.030	74.50	<del>X</del>		T	
0.032	+/-0.010	.034	<del>X</del>		✓	
4.03 Pitch	+/-0.030	4.023	<del>X</del>		✓	

Measured by: IR	Audited by: S	Prototype Approval:	N/A
Date: 10-9-14	Date: 10/09/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.09.28	Revised per Rev. B1	KJ/JLM	
C	08.07.23	Dimensions updated per Dwg Rev C	KJ/DD	

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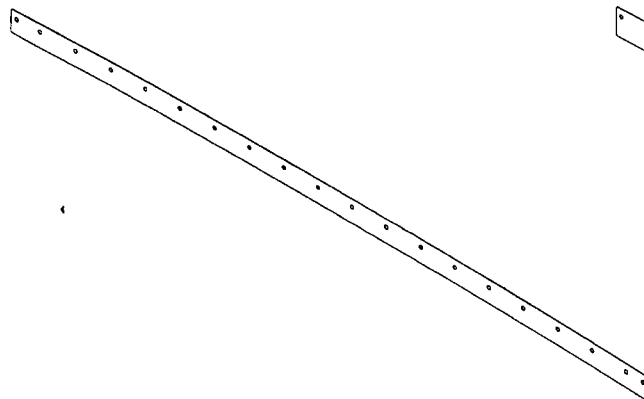
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

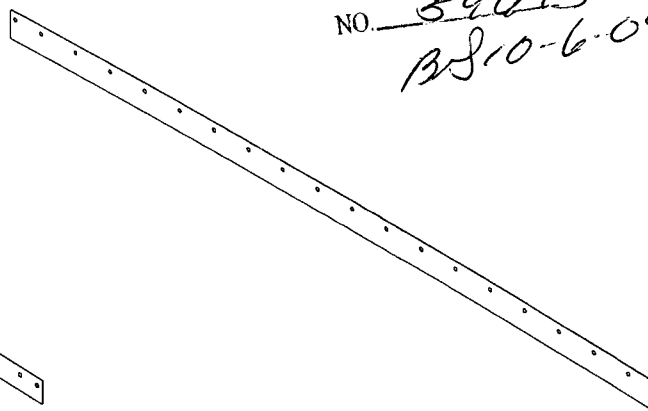
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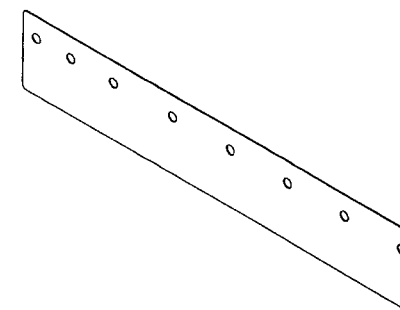
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59693  
BS10-6-09



**D3202-1 COVER**



**D3202-3 COVER**  
(COMPOSITE DOOR)



**D3202-5 COVER**  
(HINGE PANEL DOOR MOD)

**RELEASED**  
08-11-10

**NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1  
: 0.61 lbs APPROX FOR -3  
: 0.18 lbs APPROX FOR -5

D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D3202</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>COVER</b>	NTS
DATE	08.11.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

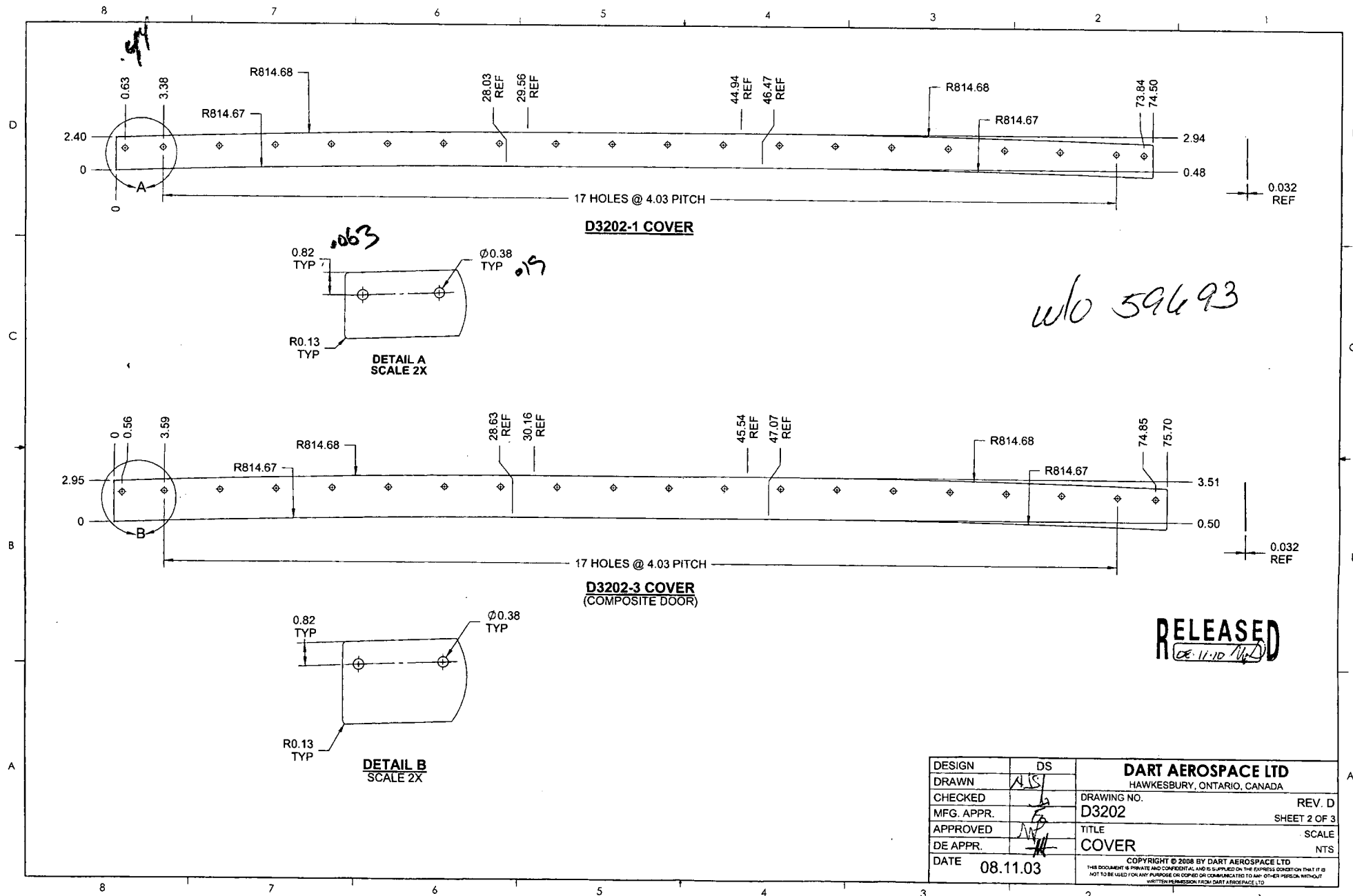
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DRAWN	AS		
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D3202	SHEET 2 OF 3
APPROVED	AW	TITLE	SCALE
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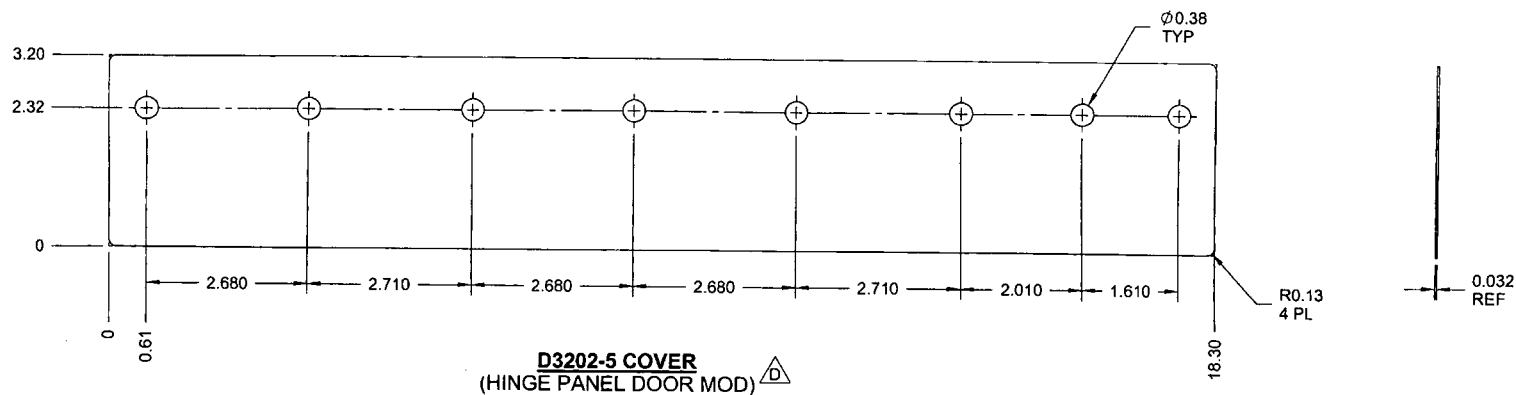
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RELEASED  
08.11.03

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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 3 OF 3
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DE APPR.		COVER	NTS
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# Dart Aerospace Ltd

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